

What I claim as my invention is:

1. A one-piece constructed tool for adapting a standard smaller collet to an oversized spindle, or collet chuck on a machine tool, comprising:
  - (a) a adapting collet tool having an external configuration sized to mate with said oversized spindle configuration and an internal configuration sized to mate with said standard collet, said adapting collet tool having a forward and rearward end;
  - (b) said configuration of adapter collet tool will mate internally to said spindle configuration, engaging said draw spindle, and said smaller collet will mate internally within matching configuration of said adapter collet tool;
  - (c) said adapter collet tool having an external annular tapered surface on the forward end, said annular tapered surface is configured and constructed to mate the oversized spindle or collet chuck configuration;
  - (d) said adapter collet tool having an internal annular tapered surface on the forward end, said annular tapered surface is configured and constructed to mate said smaller collet configuration;
  - (e) said adapter collet tool having external threads on the rearward end, said threads is configured and constructed to mate with said draw spindle of a conventional collet actuation mechanism;
  - (f) said adapting collet tool having internal threads on the rearward end, said threads is configured and constructed to mate with said smaller collet configuration;
  - (g) said smaller collect is additional held in place by the adapter collet tool set screw compressing on said smaller collect external threads to prevent rotation;
  - (h) a compression function is accomplished by the draw of the adapter collet tool via the draw spindle or draw spindle adapter;
  - (i) said draw action will draw said adapter collet tool into said spindle compressing the adapter collet tool tapered surface via said mating spindle angular tapered surface;
  - (j) said compression of the adapter collet tool will active a compression function onto said mating smaller collet angular tapered surface;
  - (k) said compression on said smaller standard collet will compress and hold parts needing machining.